

Date: Thursday, 1/25/2007 10:21:00 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: NUT PLATE		
Job Number	: 30446		Part Number	: D2680041		
Estimate Number	: 10316		Drawing Number	: D2680 REV B1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 1/25/2007	S.O. No. : <i>N/A</i>	Drawing Revision	: B1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 2/20/2007 Qty: 50 Um: Each		
Previous Run	: 28935					
Written By	: <i>[Signature]</i>					
Checked & Approved By	: <i>[Signature]</i> 07.01.25					
Comment	: Est: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM Est Rev:E Now on WaterJet 06-10-12 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET <i>ml 07-05-10</i>
2.0	WATER JET	FLOW WATER JET <i>ml 07-05-10</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>ml 07-05-10</i>
4.0	QC8	SECOND CHECK <i>ml 07-05-10</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>ml 07-05-10</i>

Comments:

- 1-Cut as per Dwg D2680
- Dwg Rev: *B1*
- Prog Rev: *B1*
- 2-Deburr if necessary
- INSPECT PARTS AS THEY COME OFF MACHINE
- SECOND CHECK
- SMALL & MEDIUM FAB RESOURCE 1

Handwritten Notes:

- Comment: N/A (circled 50)
- Comment: Est: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM
Est Rev:E Now on WaterJet 06-10-12 JLM
- Comment: FLOW WATER JET (circled 50)
- Comment: 1-Cut as per Dwg D2680 (circled 50)
- Comment: QC2 (circled 50)
- Comment: QC8 (circled 50)
- Comment: SMALL FAB 1 (circled 50)
- Comment: X50 (circled 50)
- Comment: ml 07/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:21:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 30446

Part Number: D2680041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M1103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MJ

07-05-22 (7)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-05-23

8.0 MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS20426AD3-3	Rivet	m1563 -

9.0 MS21069L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21069L4	Nut Plate	m5865 x15 mx, m100152 x 35 mx -

MF 07-05-23

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

MF 07-05-24

(SD)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07 1051 24

(SD)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/1/24 (80)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:21:00 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 30446

Part Number: D2680041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



5c

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



U 07/05/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

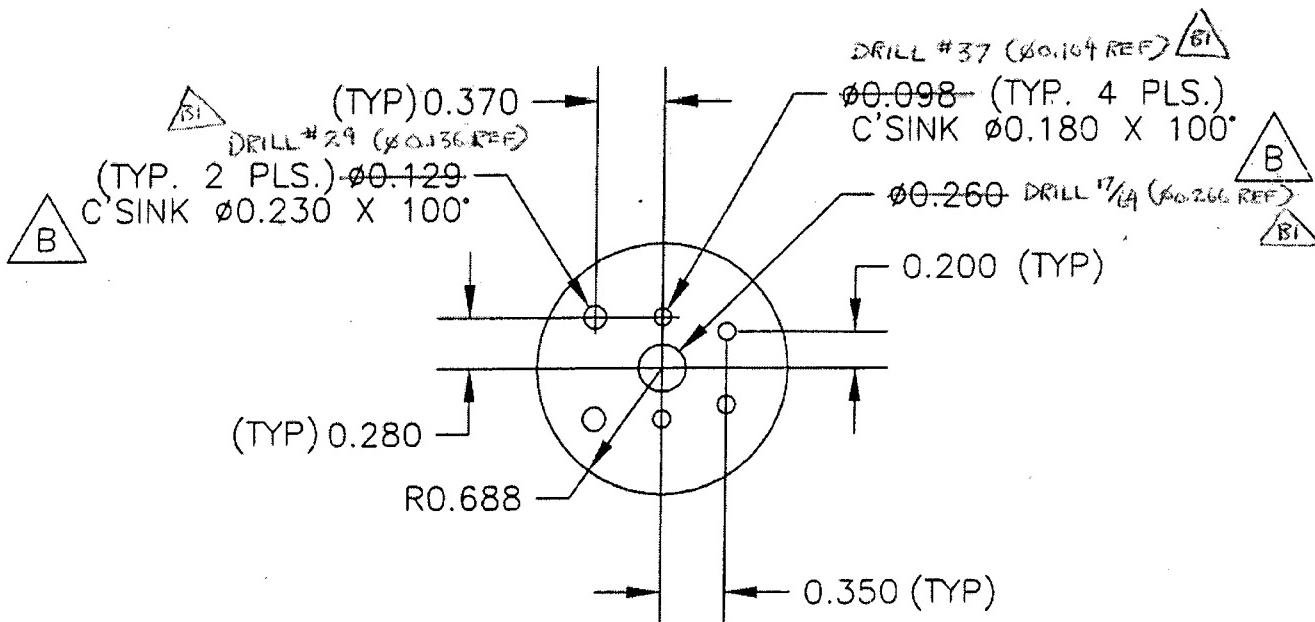
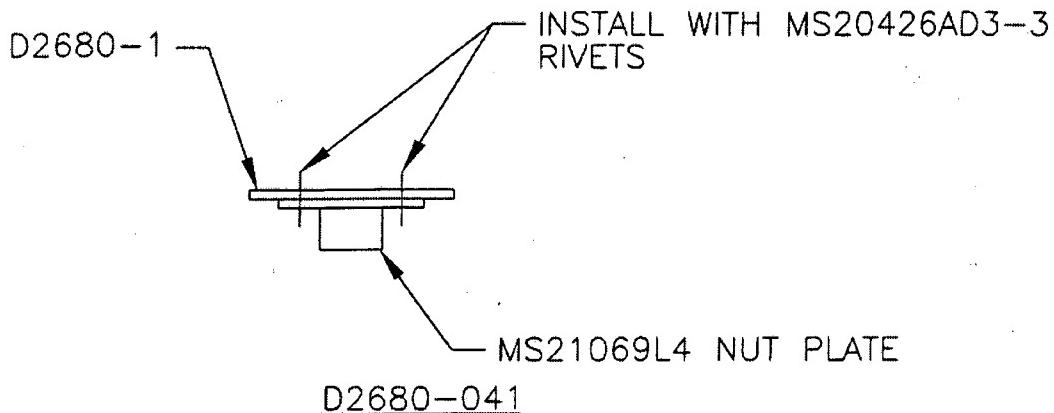
NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE USA, INC. BELLEVUE, WA		
CHECKED 	APPROVED 	DRAWING NO. D2680	REV. B SHEET 1 OF 1	
DATE 98.12.14		TITLE NUT PLATE	SCALE 1:1	
A	97.09.15	NEW ISSUE		
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)		
B1	UP 10 04.11.04	CHANGE HOLES & FINISH		

RELEASED
28.12.14 DS

12.14 D



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE

POWDER COAT WHITE (4.35.2) PER DART Q51 005 4.3

WISE SNOTED
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30446

DART AEROSPACE LTD

Work Order:

30446

Description: ~~Bear Paw Nut Plate~~

Part Number:

D2680-~~001~~-1

Inspection Dwg: D2680 Rev: B1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A Ø 0.104	+0.005 -0.001	0.104	✓		vern	
B Ø 0.266	+0.006 -0.001	0.266	✓		vern	
C Ø 0.136	+0.005 -0.001	0.136	✓		vern	
D 0.370	+1 -0.010	0.368	✓		vern	
E 0.280	+1 -0.010	0.279	✓		vern	
F R 0.688	+1 -0.010	R 0.688	✓		Radius Gauge	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: M. M.
Date: 01/05/10

Audited by: J. G.
Date: 01/05/10

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

